

# Work Order ID 53152

October 23, 2009 10:01:25 AM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: 09-10-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

*807/4/17*

*HJ for BG 09/11/17*

110

0.00



Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

*lh*

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

*m111311*  
*m111494*

*lh*

3-Grind End Plate flush

*lh*

*1209.11.09*  
*lh*

*5* *φ*

**Work Order ID 53152**

October 23, 2009 10:01:25 AM



Page 2

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				5	0	BE 09/11/09	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				5			09/11/10
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				5	0	09/11/10	

# Work Order ID 53152

October 23, 2009 10:01:25 AM



Page 3

Item ID:	D350-591-312	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Heli-Access-Step, Long RH					
Start Date:	23/10/2009	Start Qty:	5.00	Cust Item ID:		
Required Date:	18/11/2009	Req'd Qty:	5.00	Customer:		

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00				⑤			
QC Quality Control	Memo	0.00	SAD 09-11-10						
160 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Assemble Leg Assembly as per Dwg D3272.								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

N/A 10/11/06

# Work Order ID 53152

October 23, 2009 10:01:25 AM



Page 4

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Large Fab	Large Fab 1- Assy Leg per dwg <i>th</i> 0.00 2- Leave one rivet out until welding is complete <i>th</i> 0.00 Memo 3- Bevel Aft end for welding <i>th</i> 4- Inspect for foreign object as per QSI 024 <i>th</i> 5- Weld Aft End Plate as per QSI 004 & Dwg D3272 <i>th</i> A/R Aluminum Rod <i>m111311</i> <i>th</i> 6- Grind End Plate flush <i>th</i> 7- Install last rivet. <i>th</i>					5	<del>0</del>		
190  QC	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00							
Quality Control									

*th* 09-11-10

*th* 09/11/06

*th* 09.11.11 (5)

**Work Order ID 53152**

October 23, 2009 10:01:25 AM



Page 5

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				5			05-11-12
Quality Control									
210	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
220	+pressure wash White Gloss(Ref:4.3.5.1) per QSI005 4.3-AJum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 2:45pm								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 3:15pm								

# Work Order ID 53152

October 23, 2009 10:01:25 AM



Page 6

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

230 Wing Walk as per dwg QSI005 4.4 Batch *m1263*



HandFinish

Memo

0.00

Hand Finishing

*MO 09/11/16*

*KS*

240 QC3- Inspect Part Finish



QC

Memo

0.00

Quality Control

*BR 09-11-17*

*Q*

250 Pick Kit



Packaging

Memo

0.00

Packaging

*9/11/17 @ SP*

**Work Order ID 53152**

October 23, 2009 10:01:25 AM

Page 7

Item ID: D350-591-312

Accept

Setup Start

Revision ID: B

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009 Start Qty: 5.00

Cust Item ID:

Required Date: 18/11/2009 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260

QC4- 100% Inspect kits for completeness

0.00



27 Sorhuliz

QC

Memo

0.00

Quality Control

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312  
Location: RVB

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

# Picklist Print

Page 1

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 23/10/2009

Required Date: 18/11/2009





Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA  End Plate		Manufactured	No			110	Each	68.0000	5.0000		<i>18.11.09</i>	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	68	
51546	68	

D3272-1RevB  Step MS21042L5 <i>2</i>  Nut		Manufactured	No			110	Each	0.0000	5.0000		<i>18.10.28 353167</i>	
		Purchased	No			110	Each	1,077.000	10.0000		<i>9/11/17 SP (50)</i>	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1077	
110382	10	
111127	4	
111636	63	
112314	1000	

*10x50*



# Picklist Print

Page 2

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH


Start Date: 23/10/2009

Required Date: 18/11/2009


Comments:

Start Qty: 5.00


Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Loc Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-041RevB  Step Leg Assembly Hi		Manufactured	No			160	Each	62.0000	5.0000		09.11.10	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	22	
51125	22	
Main Warehouse		
WA	40	
52104	40	

D3066-1RevB  Spacer		Manufactured	No			160	Each	74.0000	10.0000		09.11.10	
--	--	--------------	----	--	--	-----	------	---------	---------	--	----------	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	74	
51545	74	

D3219-1RevA  Plate		Manufactured	No			160	Each	128.0000	10.0000		09.11.09	
---	--	--------------	----	--	--	-----	------	----------	---------	--	----------	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	128	
52230	128	

October 23, 2009 10:01:29 AM

Shop Packet Print

Page 2

# Picklist Print

Page 3

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4		Purchased	No			180	Each	2,495.000	80.0000			
Rivets												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2495	
110731	215	
111359	46	
111477	74	
112314	1960	
112385	200	

AN3-35A

Purchased

No

260

Each

441.0000

10.0000

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	441	
106993	12	
110467	1	
112314	428	

October 23, 2009 10:01:29 AM

Shop Packet Print

Page 3

# Picklist Print

Page 4

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 23/10/2009

Required Date: 18/11/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-13A

Purchased

No

260

Each

308.0000

40.0000

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

308

107321

1

107534

5

107959

23

109285

37

110552

66

110865

3

111477

9

111925

7

112314

157

17406

0

51764

0

M113149

(40x) SP

October 23, 2009 10:01:29 AM

Shop Packet Print

Page 4

# Picklist Print

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH


Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-36A  Bolt		Purchased	No			260	Each	415.0000	10.0000		9/11/17	sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	415	
109545	11	
110467	7	
110731	4	
112243	20	
<del>112314</del>	323	
112385	50	

AN960JD10/

Purchased

No

260

Each

1,897.000

20.0000

  
Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	1897	
105442	95	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	1000	
112369	506	

# Picklist Print

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH



Comments:

Start Date: 23/10/2009

Required Date: 18/11/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416/  Washer		Purchased	No			260	Each	4,779.000	80.0000		9/11/17	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	4779	
108161	521	
110523	340	
111279	101	
111916	482	
<del>112314</del>	3335	
16941	0	

80 x 50

# Picklist Print

Page 7

October 23, 2009 10:01:29 AM

Work Order ID: 53152



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH


Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516  Washer		Purchased	No			260	Each	1,595.000	20.0000			

Sp  
x4

9/11/17 50 50

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1595	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	68	
112314	500	
112794	181	
112828	500	

20x50

# Picklist Print

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-3RevG

x4

Manufactured

No

260

Each

225.0000

20.0000

9/11/17

sl



Lug

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

27

51568

27

Main Warehouse

ST176

198

51428

198

20xsl

D2618RevB1

x2

Manufactured

No

260

Each

271.0000

10.0000

9/11/17

sl



Bushing

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST39

271

50989

200

51189

71

10xsl

# Picklist Print

Page 9

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2856-400RevA *x2 @ 7.20<sup>m</sup>* Manufactured No

260 f 167.3337 3.0000



Abrasion Strip

Warehouse

Loc Qty

Loc Code

Location

B52563

*10x sl*

Main Warehouse

ST403

167.3336842

50593

167.333684

D3067-1RevA

Manufactured No

260 Each 68.0000 5.0000



End Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

68

51546

68

*5*

D3235-1RevA *x2*

Manufactured No

260 Each 113.0000 10.0000



Mounting Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

113

45398

4

46745

9

47969

100

*10x sl*

October 23, 2009 10:01:29 AM

Shop Packet Print

Page 9



# Picklist Print

October 23, 2009 10:01:29 AM

Work Order ID: 53152

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq iD	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
86 D3278-041RevC Support Assembly	x1	Manufactured	No			260	Each	83.0000	5.0000	9/11/17	SL	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

73

52075

73

Main Warehouse

ST471

10

51191

10

86 MS21042L3  
Nut

x2

Purchased

No

260

Each

3,430.000

10.0000

9/11/17

SL

(52)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3430

110844

32

111274

35

111668

863

112314

2000

112385

500

10x50

# Picklist Print

Page 11

October 23, 2009 10:01:29 AM

Work Order ID: 53152



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 23/10/2009

Required Date: 18/11/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4  Nut		Purchased	No			260	Each	6,002.000	40.0000			

8x



9/11/17

5x50

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

6002

110507

184

~~111827~~

5809

112314

9

15924

0

40x50



DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53152  
*[Signature]* 09-10-23

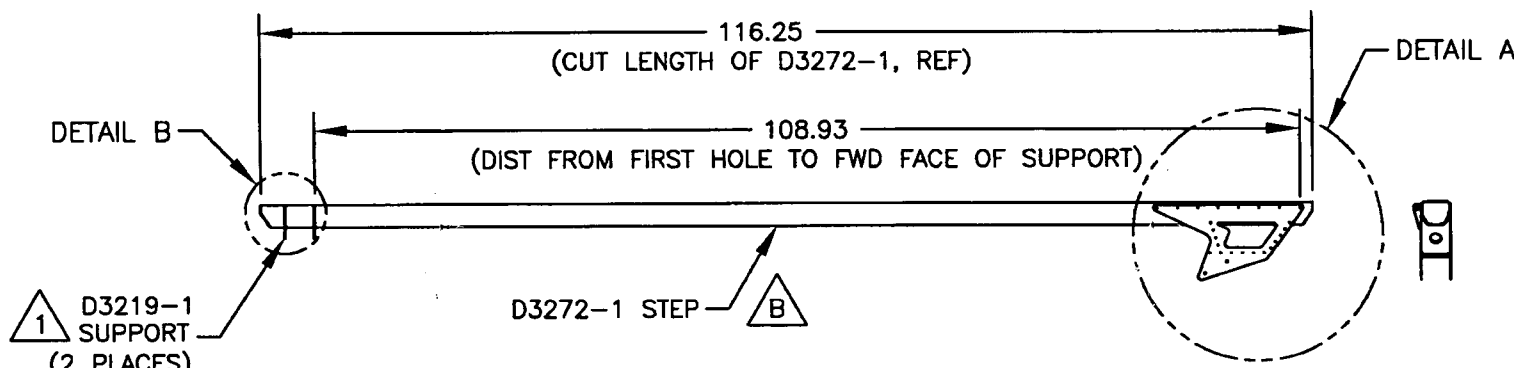
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

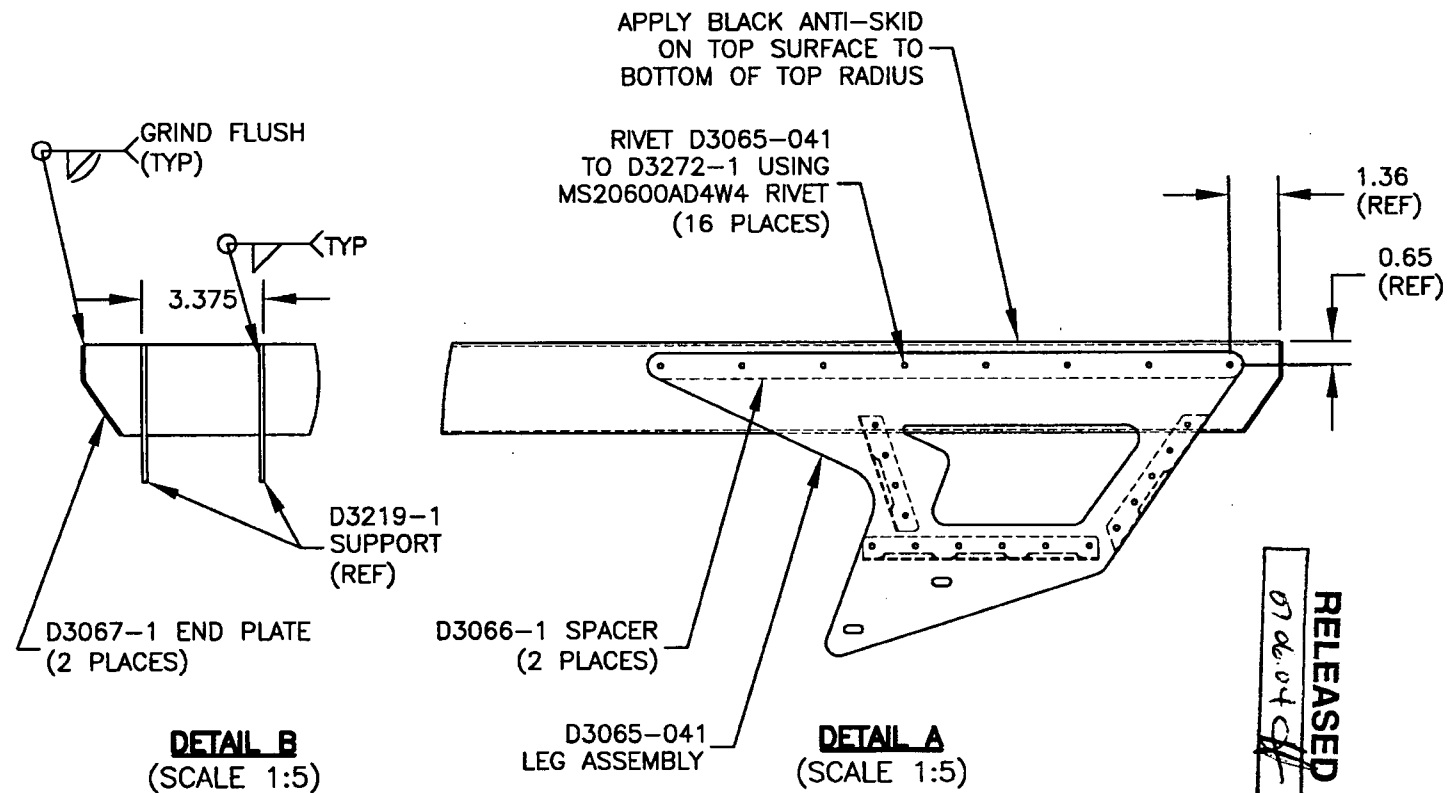


DESIGN	q	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	CE	APPROVED	DRAWING NO.	REV. B
DATE	07.05.18		D3272	SHEET 2 OF 3
		TITLE	STEP ASSEMBLY, HI LONG	SCALE
				1:20

w/058152

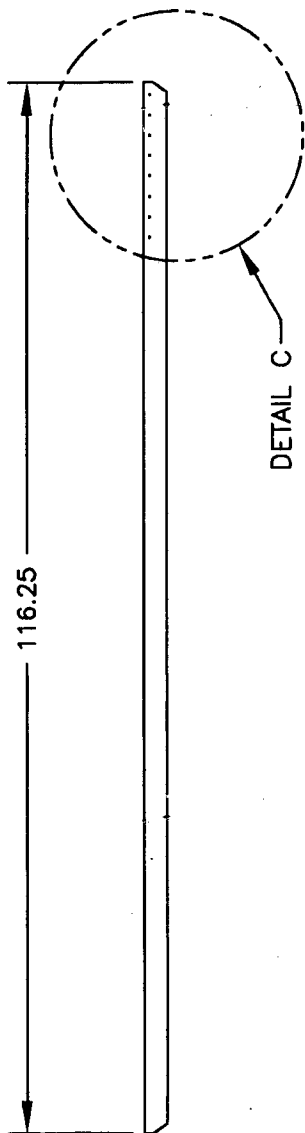


**D3272-041 STEP ASSEMBLY (L.H. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



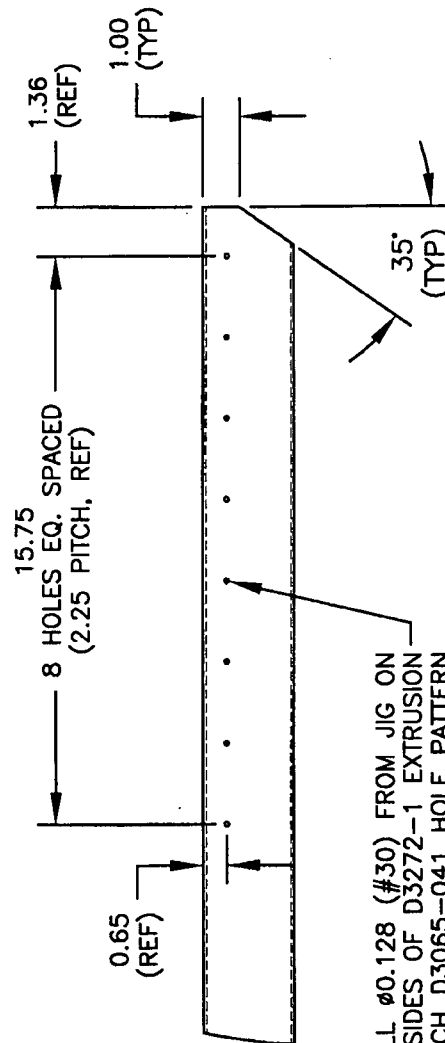


DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



**DETAIL C**  
**△ D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)

*w/b 53152*



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

**RELEASED**

07.06.04 *[Signature]*

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# REFERENCE ONLY

DART AEROSPACE LTD.

D350-591  
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

53152

• COPYRIGHT © 1993 BY DART AEROSPACE LTD. •  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: G  
Date: 08.10.06